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D5068-041
Job Sheet 183913



Part No: D5068-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, LH/RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/28/18

Job Tracking No:

Due Date: 10/12/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D5068 REV.A IPP REV:A 17.08.30 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	1 Ea		10/12/18	0.00	0.00	Start Up Large Fab-7		CC
110	Large Fab	1 pcs		10/12/18	0.00	20.00	Large Fab 1		CC
120	QC	1 pcs		10/12/18	0.00	0.00	QC9		CC
130	QC	1 pcs		10/12/18	0.00	0.00	QC5		CC
140	HandFinish	1 pcs		10/12/18	0.00	0.25	HandFinish2		BE 3-18-10-23
150	Powdercoat	1 pcs		10/12/18	0.00	0.50	Powdercoat2		BE 3-18-10-23
160	QC	1 pcs		10/12/18	0.00	0.00	QC3		BE 3-18-10-23
170	HandFinish	1 pcs		10/12/18	0.00	0.25	HandFinish4		BE 3-18-10-23
180	QC	1 pcs		10/12/18	0.00	0.00	QC5		BE 3-18-10-23
190	Packaging	1 pcs		10/12/18	0.00	0.00	Packaging3-2		21 OCT 2 4 2018
200	QC21-SA	1 Ea		10/12/18	0.00	0.00	QC21		21 OCT 2 4 2018

Part Op 110 - 1- Assemble ribs , weld as per dwg D5068 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D5068 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- Weld hinge (3) and Mounting brackets as per dwg D5068 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg

150 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat 2-Mask this area prior to finish section A-A,

B-B 3-1ST COAT: START TIME: 1:25 OVEN TEMPERATURE: 375° FINISH TIME: 1:40

***** 2nd coat if necessary ***** 2ND COAT: START TIME: OVEN

TEMPERATURE: FINISH TIME:

170 - ASSEMBLE BLANKING PLATE AND BUMPER AS PER DWG

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	100-Start up Operation	5105222
D3913-1	Rib	1 Ea (1 ea)	100-Start up Operation	5112746
D3913-15	Wide Handle Plate	1 Ea (1 ea)	100-Start up Operation	5108592
D3913-3	Rib	1 Ea (1 ea)	100-Start up Operation	5112730
D3913-9	Hinge Rib	1 Ea (1 ea)	100-Start up Operation	5104485
D3916-041	Rib Assembly	2 Ea (2 ea)	100-Start up Operation	5111464
D3916-5	Light Rib	2 Ea (2 ea)	100-Start up Operation	5114158
D4016-1	Hinge Half, Base	3 Ea (3 ea)	100-Start up Operation	5115309
D4017-7	Rib	3 Ea (3 ea)	100-Start up Operation	5110037
D4020-11	End Mesh, Basket	2 Ea (2 ea)	100-Start up Operation	5109707
D4021-1	Handle Plate	3 Ea (3 ea)	100-Start up Operation	5108590

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : ☐									

D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	100-Start up Operation
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	100-Start up Operation
D4672-1	Blanking Plate	2 Ea (2 ea)	100-Start up Operation
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	100-Start up Operation
D4785-117	Rib Assembly	2 Ea (2 ea)	100-Start up Operation
D5068-1	Rib	2 Ea (2 ea)	100-Start up Operation
D5068-3	Rib	2 Ea (2 ea)	100-Start up Operation
D5068-5	Rib	1 Ea (1 ea)	100-Start up Operation
AN3-10A	Bolt	6 Ea (6 ea)	170-HandFinish
D2931	Bumper	2 Ea (2 ea)	170-HandFinish
D4021-5	Blanking Plate	2 Ea (2 ea)	170-HandFinish
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	170-HandFinish
MS21042L3	Nut	6 Ea (6 ea)	170-HandFinish
NAS1149F0332P	Washer	12 Ea (12 ea)	170-HandFinish
NAS1149DN832J	Washer	2 Ea (2 ea)	170-HandFinish

5113926
 5113925
 5098025
~~5098025~~
 5047859 5093684
 5047859 504483
 5037268 5042859
 5043099 5034268
 5043099
 5106452
 506435
 506637
 5076067
 5094592-1
 5103666
 50344-1

Job Allocations

006055

Operation	Component Part	Required	Inventory	Allocated
100-Start up Operation	D2581	2	78	0
	D3913-1	1	10	0
	D3913-15	1	12	0
	D3913-3	1	11	0
	D3913-9	1	5	0
	D3916-041	2	12	0
	D3916-5	2	17	0
	D4016-1	3	37	0
	D4017-7	3	31	0
	D4020-11	2	21	0
	D4021-1	3	27	0
	D4034-041	1	5	0
	D4034-043	1	5	0
	D4672-1	2	22	0
	D4785-117	2	4	0
	D5068-1	2	6	0
	D5068-3	2	6	0
	D5068-5	1	3	0
	M304EX0.75-16F	33	1,601	0
170-HandFinish	AN3-10A	6	299	0
	D2931	2	952	0
	D4021-5	2	40	0
	MS20600-AD4W3	2	350	0
	MS21042L3	6	3,023	0
	NAS1149DN832J	2	1,213	0
	NAS1149F0332P	12	3,025	0

Part Specifications

Specifications could not be found.

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION	AGAINST
	Rework ☐	Skid-tube ☐ Cross tube ☐
Part No. _____	Scrap ☐	Machining ☐ Small Fab ☐
	Use-as-is ☐	Thermoforming ☐ Finishing ☐
NCR No. _____	Suspected Unapproved ☐	Large Fab ☐ Composite ☐

Date :	Step #:	QTY Effective :
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Description Work Order Deviation	Disposition

QC / QA Coordinator
Approval

Root Cause			FAULT CATEGORY		
Environment	No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong
Design	Operator	Bending	Set-up	Folio/Program	Outside Dimensions
Doc/Data	Offset/Setup	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance
Equip/Tooling	Supplier	Cracks	Broken/Damage/Defect	Weld	Part Incorrect
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing
Material	Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved
Internal Transport	Poor Information	Crushing	Countersink	Off-set	Drawing
Tribal Knowledge	Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish
LOA	Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread
Substation	Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence
Past Expiry Date	Manufacturing Process				
Misidentified	Past Due	OTHER :			

Part: D5068-041
Job No: 183913
Serial No/Batch: S115816
Revision: A
Inspector:
Exp Date:
Instructions: Various STC's

Date: 10/03/18

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